

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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☐ OTHER : _____																																																																									

Work Order ID 164227

Friday, July 14, 2017 11:55:16 AM

164227

Page 2

Item ID: D2651-1BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 8/4/2017 Start Qty: 500.00 ***500*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 500.00 ***500*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

3,512.22

Hand Finishing

150

0.00

150

Purchasing

Memo

0.00

Purchasing

ISSUE PO 37816

(Only larger section necessary)

PRIME:

Start Time: _____

Finish Time: _____

PAINT: DELFLEET BLUE _____

Start Time: _____

Finish Time: _____

CLEAR DELFLEET B _____

50002017-09-12
JSL500DLB

SEP 20 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	Receive & Inspect for Damage & Mat'l Certs	0.00							
155									
Packaging	Memo	0.00							
Packaging									
160	QC14- Inspect Spray Paint	0.00							
160									
QC	Memo	5.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	5.00							
Packaging	LOCATION : FP001								

500 X SP 29-27

500

DAS
38
9-89

SEP 27 2017

x500 d all stock

DQA: _____ Date: _____

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				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	50.00							
Quality Control									

DAS
21
9-88

SEP 27 2017

DQA: _____ Date: _____



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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, July 14, 2017 11:55:19 AM

Page 1

Work Order ID: 164227

164227

Parent Item: D2651-1BL

***D2651-1BL ***

Parent Item Name: Plug

Start Date: 8/4/2017

Required Date: 9/25/2017

Start Qty: 500.00

Required Qty: 500.00

Comments:

IPP: A02.04.15New Issue NG
IPP: B05.12.12added deburr EC
15.10.09 ADDED BL DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	27.1725	0.0401	21.10526			

M6061T6R0 500

6061-T6 Round Bar .500"

M6061T6R0.500
M137762

Location

MAT010

Loc Qty

27.1725

Loc Code

M136896

3.065

M137762

24.1075

M138109

18.245

5.849

17/9/11



Work Order update only ☐

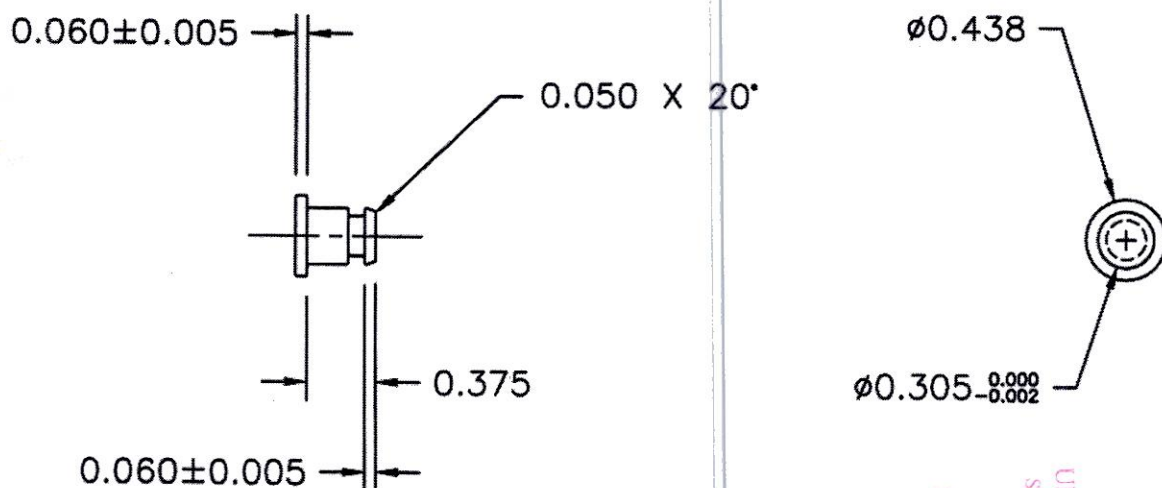
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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
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OTHER :									



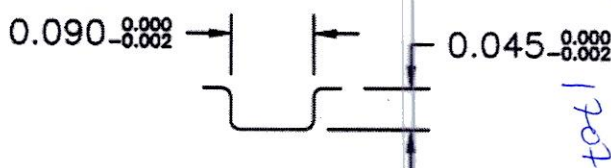
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164227 M.C.
120714

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37816

Purchase Order Date 9/20/2017

PO Print Date 9/20/2017

Page Number 1 of 2

Order From :

VC-ATE001

ATELIER DEBOSSSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone 819 242 5633

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

Terms

Currency

FOB

10127-2607

Net 30

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	164227 as per Dwg D2651 Rev B B164227 Prime and paint Delfleet Blue	D2651-IBL Plug	9/22/2017 Yes 9/22/2017		500.00	\$18.00	\$9,000.00
Line Total:							\$9,000.00
2	164245 As per Dwg D2731 Rev C B164245 Prime and spray paint Delfleet Blue	D2731-7 Mounting Lug	9/22/2017 No 9/22/2017		76.00	\$18.00	\$1,368.00
Line Total:							\$1,368.00

Note:

9/20/2017